

Fire Red

Dart Aerospace Ltd.

Date: Friday, 13/02/2009 1:02:28 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL LOCK COVER
Job Number : 45790	
Estimate Number : 10445	
P.O. Number :	Part Number : D33683
This Issue : 13/02/2009 S.O. No. :	Drawing Number : D3368 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 44256	Material :
Written By :	Due Date : 20/02/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 09.02.13</u>	
Comment : Est. A 05.01.27 New issue KJ/JLM Est Rev:B 08-07-15 add QC3 DD verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X02000	6061-T6 Bar 2.00 x 2.00
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Comment: Qty.: 0.9277 f(s)/Unit Total : 5.5661 f(s)
Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)
(M6061T6B2.000x02.000)
Batch: 7110 167

mk 09/02/15

⑥

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine D3368-3 as per Folio FA500 and Dwg D3368
Identify as D3368-3
Deburr

JL 09/02/17 ⑥

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 09/02/17

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SL 09/02/17 ⑥

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

SL 09-02-17 ⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/02/2009 1:02:28 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK COVER

Job Number: 45790

Part Number: D33683

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

7:30am

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:00am

ell 09-02-18

Y6

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/18

(G)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

09/2/18 (8)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/19

Job Completion



MF 09-02-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45790
Description: Pedal Lock Cover		Part Number: D3368-3
Inspection Dwg: D3368 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/-0.030	10.251	/			
7.250	+/-0.010	7.250	/			
0.650	+/-0.010	.650	/			
0.107	+/-0.010	.108	/			
1.800	+/-0.010	1.796	/			
45°	+/-0.5°	45°	/			
Ø1.300	+/-0.010	1.302	/			
Ø1.400	+/-0.010	1.391	/			
Ø1.031	+/-0.010	1.033	/			
0.250	+/-0.010	.245	/			
1.500	+/-0.010	1.500	/			
1.440	+/-0.010	1.436	/			
2.00	+/-0.030	1.995	/			
7°	+/-0.5°	7°	/			
0.635	+0.010/-0.000	.640	/			
Ø1.250	+/-0.005	1.250	/			
0.250 deep	+/-0.010	.250	/			
1.000	+/-0.010	.998	/			
1.450	+/-0.010	1.450	/			
0.375	+/-0.010	.376	/			
0.310	+/-0.010	.308	/			
Ø0.750	+0.010/-0.000	.755	/			
Ø0.185	+0.005/-0.000	.189	/			

Measured by:	J.L.
Date:	09/02/17

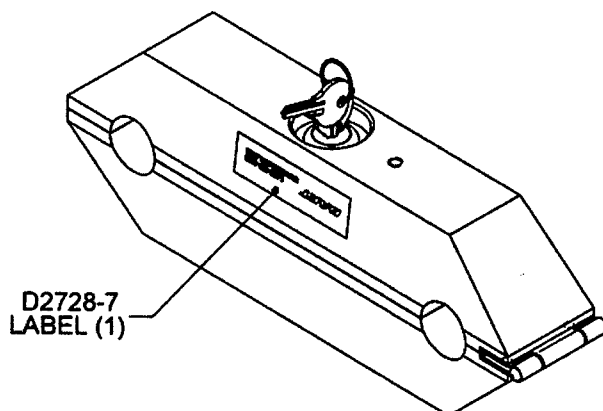
Audited by:	85
Date:	09/02/17

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Dimensions and tolerances changed	KJ/JLM	
C	08.07.23	Ø0.201 & Ø0.136 dimensions removed	KJ/DD	

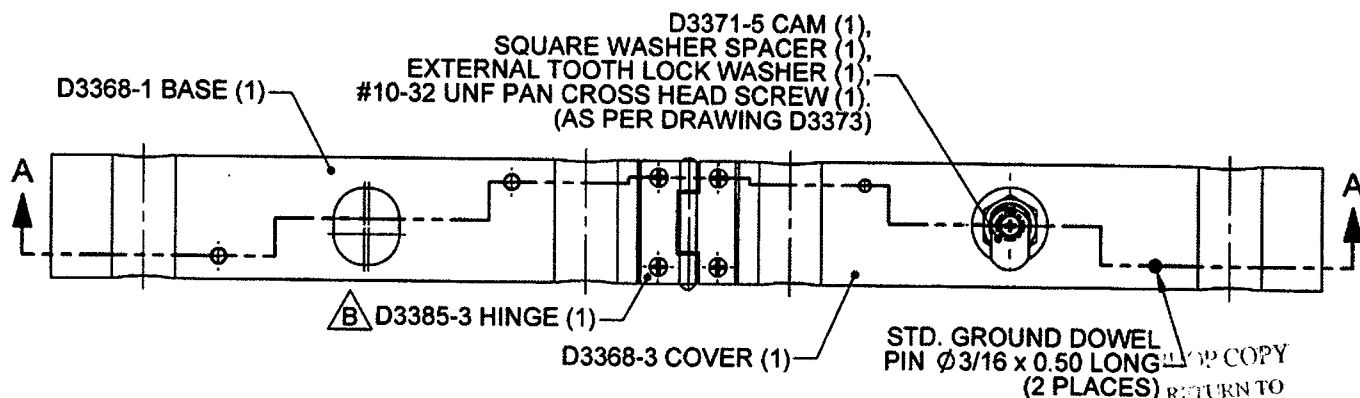
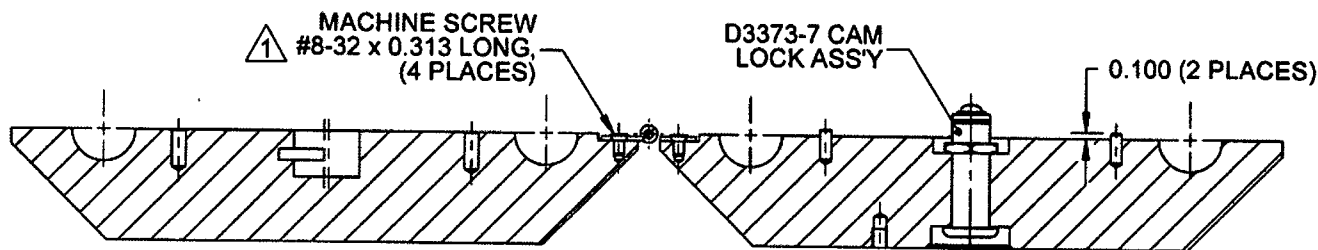
DART

DESIGN 43	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3368	REV. B SHEET 1 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



RELEASED
[Signature]
05/04/20

PEDAL LOCK SHOWN LOCKED WITH KEY



D3368-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

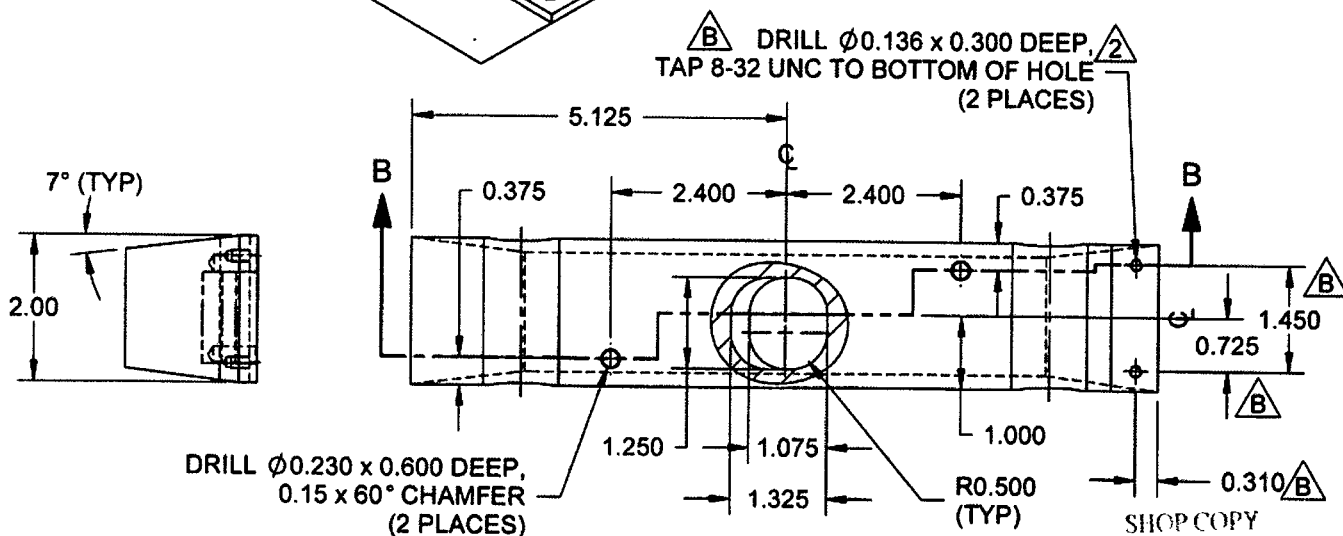
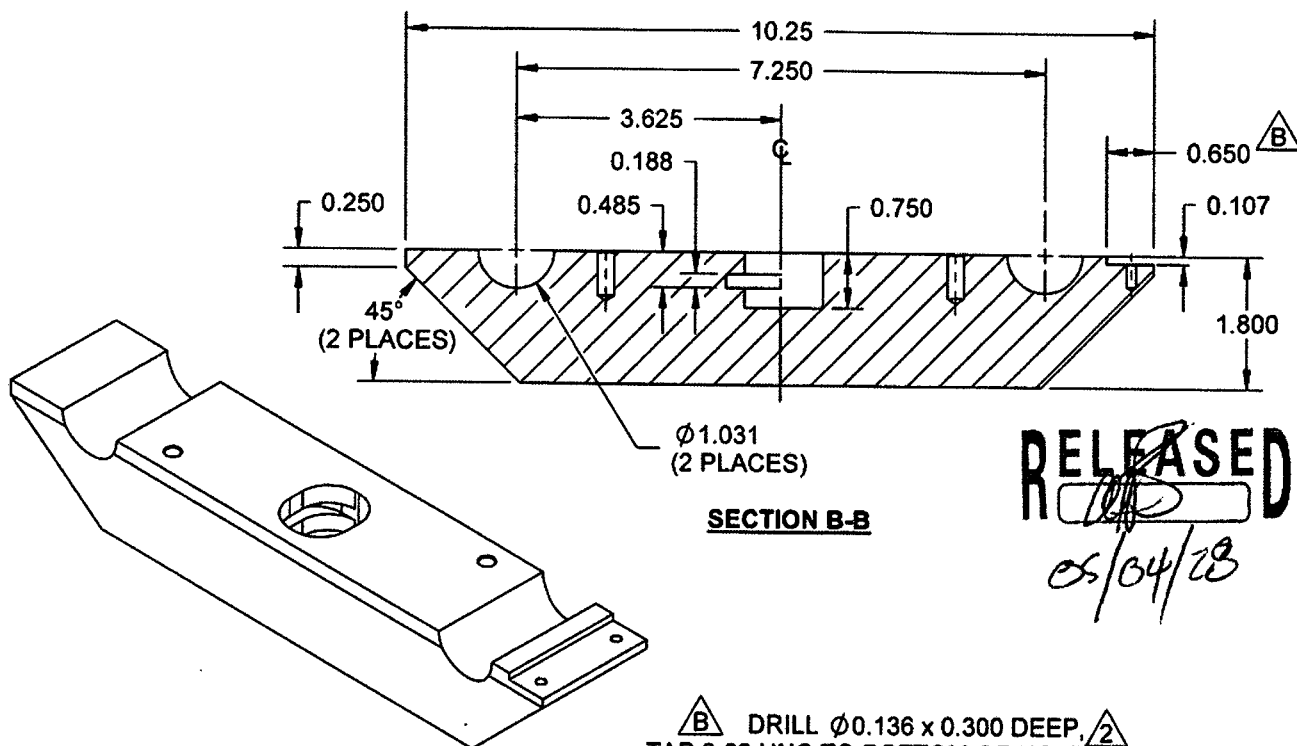
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WORK ORDER
NO **45790**

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 2 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2.5

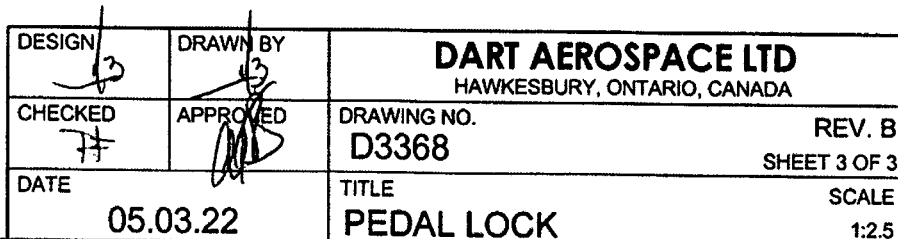
**D3368-1 BASE****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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45790

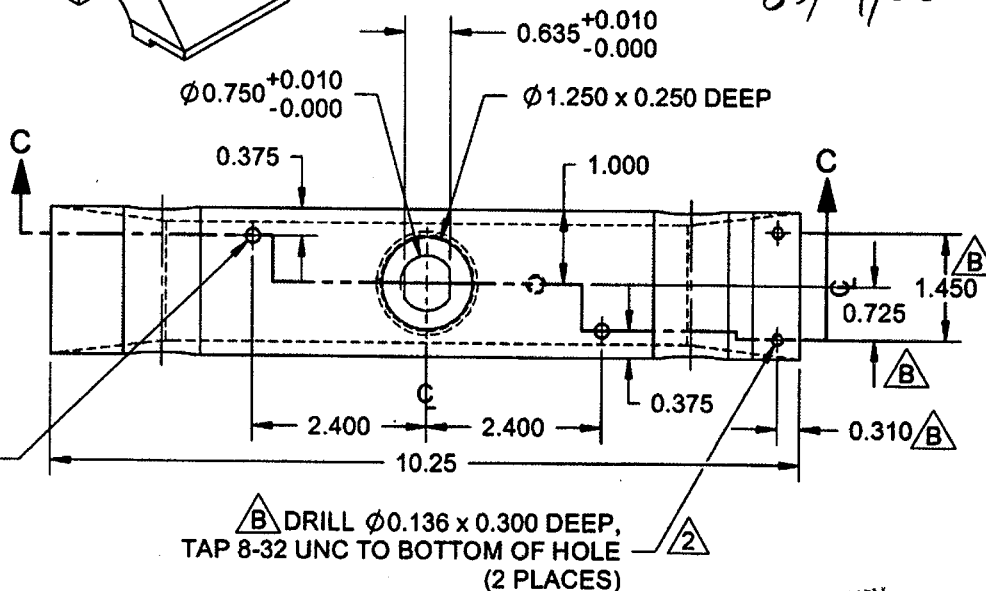
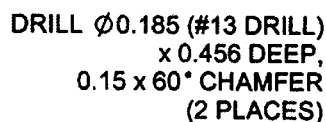
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RELEASED

05/04/28



NOTES:

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